

Work Order ID 86585

July-05-12 1:14:25 PM

86585

Page 1

Item ID: D2989-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 7/05/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: CS Date: 12/07/05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989
 2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
 3- to locate hinges and shims use D2989-041, weld as per dwg D2989
 A/R ER316 S.S. Rod Batch: 11/22/130

Pl 12.12.17

1x

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

DA 23 18
 12.12.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00 12/12/18	DAS 15 8-89	DAS 09 8-89		1			
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00				1	16	12-12-18	

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
-----	---	------	--	--	--	--	--	--	--

130

Powdercoat Memo 0.00

Powder Coating 1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT
 START TIME: 1:00
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 1:20
 ***** 2nd coat if necessary *****

2ND COAT:
 START TIME: 2:00
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 2:30

140	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--



140

QC Memo 0.00

Quality Control

W123343

LX  12/12/18

1  12-12-19 

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>D350-607-043</u>		87538			1	0	12-12-19	
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

mf
12-12-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 86585
Parent Item: D2989-043
Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	8.0000	1	1	24 2.89	12.12.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
				83907		8							
D2989-3 Rib		Manufactured	No			100	Each	5.0000	1	1	24 2.89	12.12.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		4							
				77527		4							
				WA005		1							
				72408		1							
D2989-4 Rib		Manufactured	No			100	Each	5.0000	1	1	24 2.89	12.12.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		5							
				72409		1							
				77524		4							
D2989-5 Rib		Manufactured	No			100	Each	4.0000	2	2	24 2.89	12.12.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		3							
				81911		3							
				WA005		1							
				71222		1							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

Work Order ID: 86585
Parent Item: D2989-043
Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D3182-1
Hinge

Manufactured No

100 Each 12.0000 2

DAS 24 12.12.12

Location Loc Qty Loc Code

WA 12
77316 4
82707 8

B70725

D3442-3
Shim

Manufactured No

100 Each 14.0000 2

DAS 24 12.12.12

Location Loc Qty Loc Code

WA 14
79123 6
82708 8

B79123

D3827-041
Rib Assembly (Inboard)

Manufactured No

100 Each 11.0000 1

DAS 24 12.12.12

Location Loc Qty Loc Code

WA 5
81038 5
WA006 6
72729 1
84792 5

B87587

D3832-5
Mesh (Lid)

Manufactured No

100 Each 0.0000

DAS 24 12.12.12

D3833-5
Mesh (Lid End)

Manufactured No

100 Each 38.0000

DAS 24 12.12.12

Location Loc Qty Loc Code

WA035 38
67461 38

DAS 24 12.12.12

D3838-041
Rib Assembly (Basket Lid, LH)

Manufactured No

100 Each 5.0000 1

B89333

Location Loc Qty Loc Code

WA005 5
77525 5

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 86585

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

~~D3838-042~~

Manufactured No

100 Each 5.0000 1

Rib Assembly (Basket Lid, RH)

24
12-12-12
B 84798

Location

Loc Qty

Loc Code

WA005

5

72415

1

77526

4

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Shop Packet Print

Page 3

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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

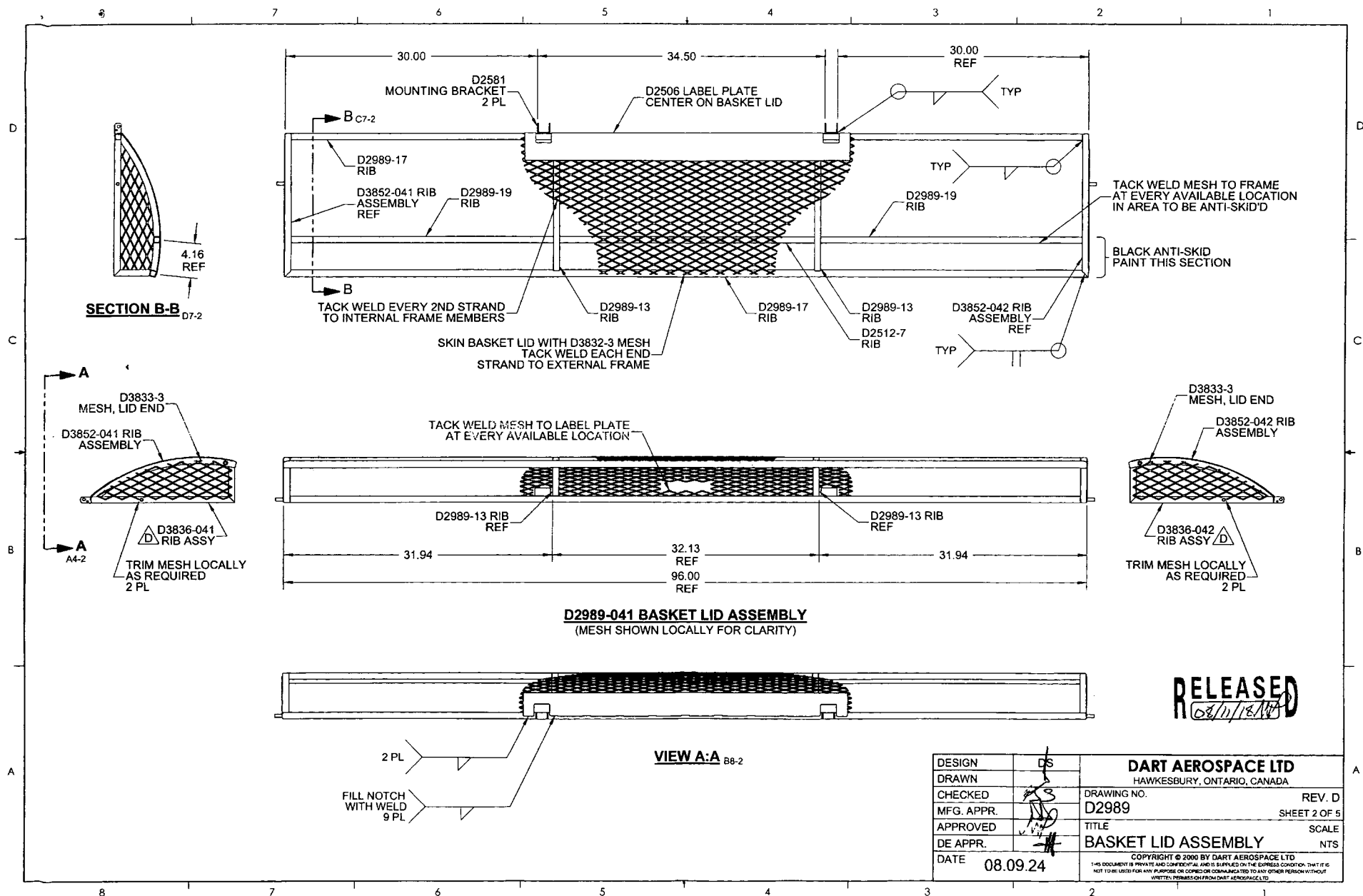
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08/11/16

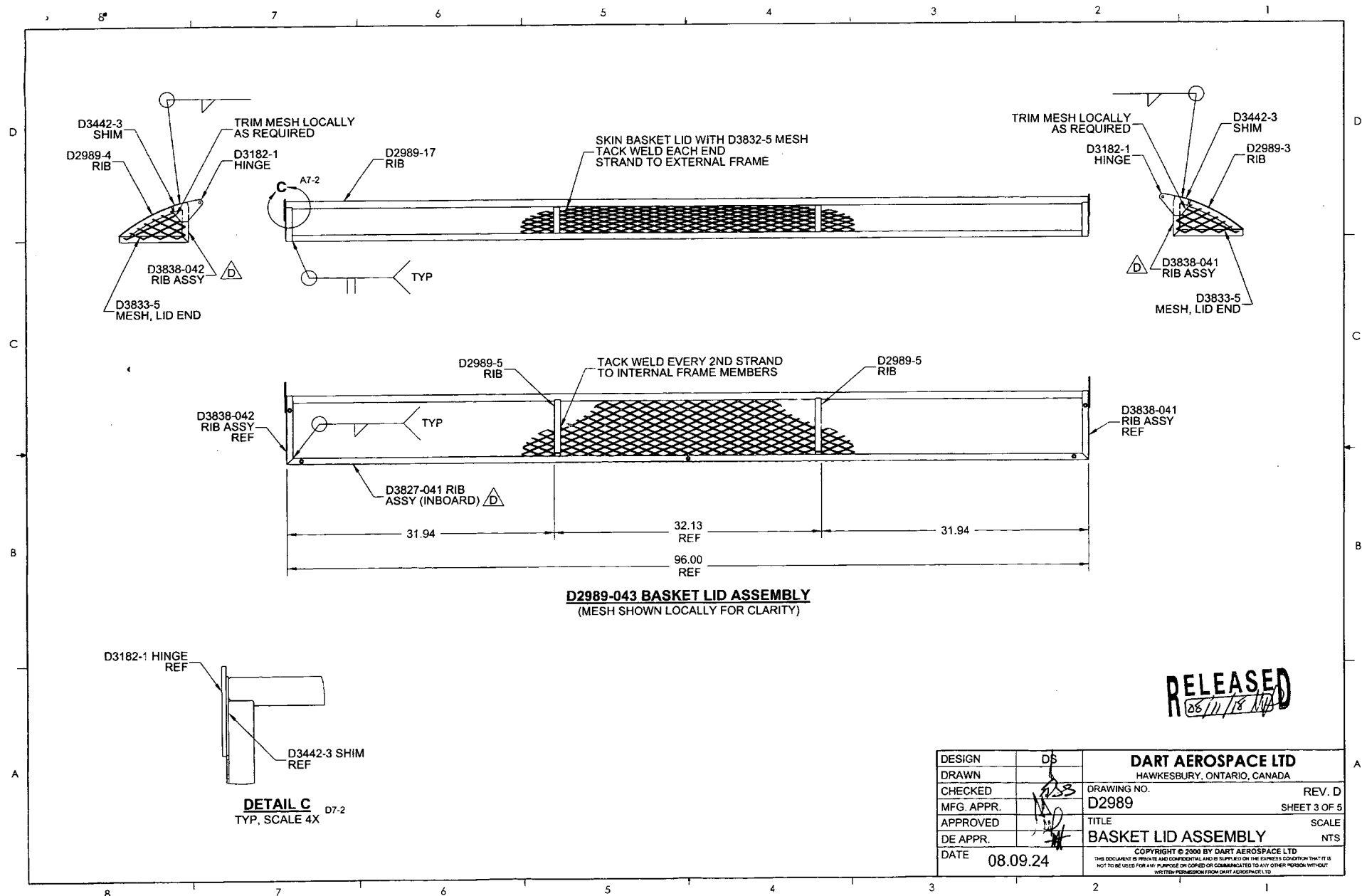
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE

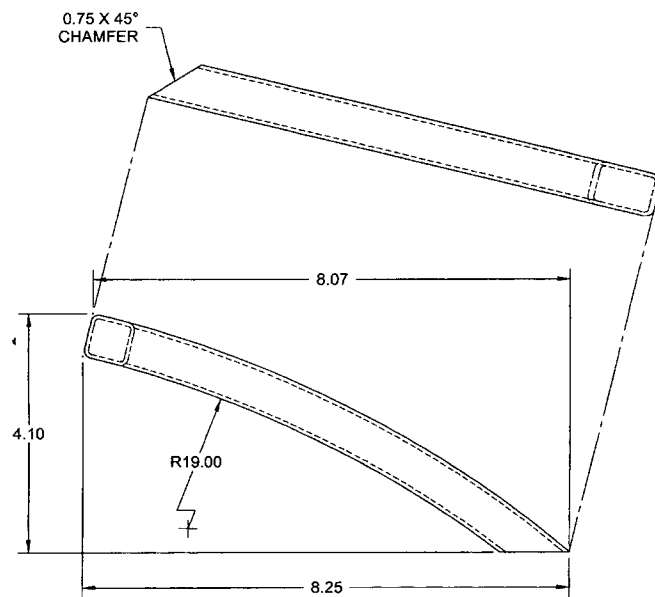
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
DRAWN		DRAWING NO.	SHEET 1 OF 5
CHECKED		D2989	
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.24		

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

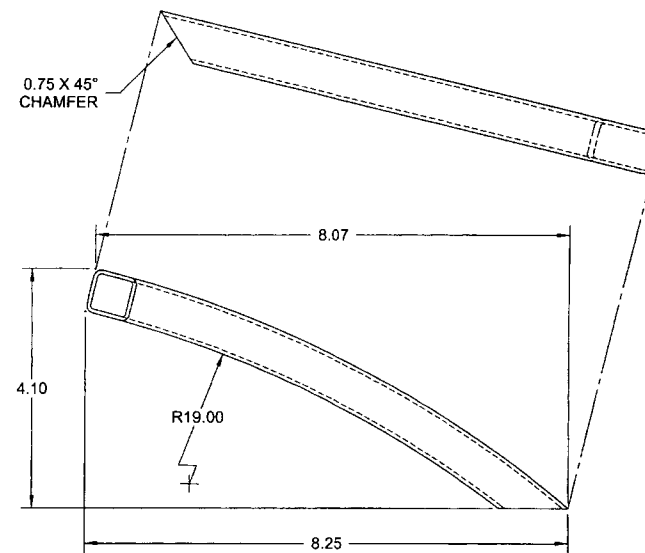
CX12107105
W10: 86585



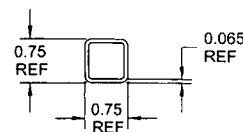




D2989-3 RIB



D2989-4 RIB

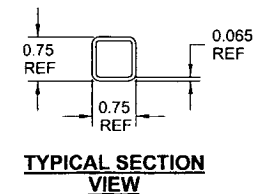
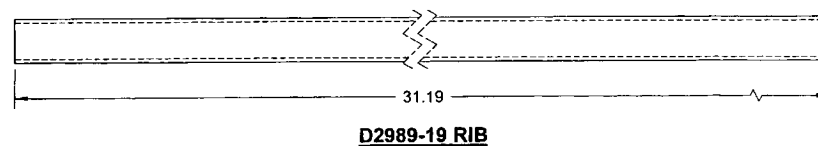
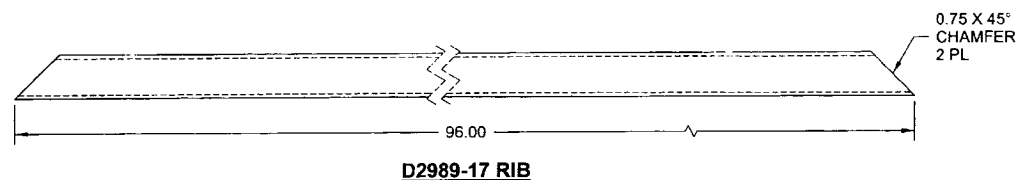
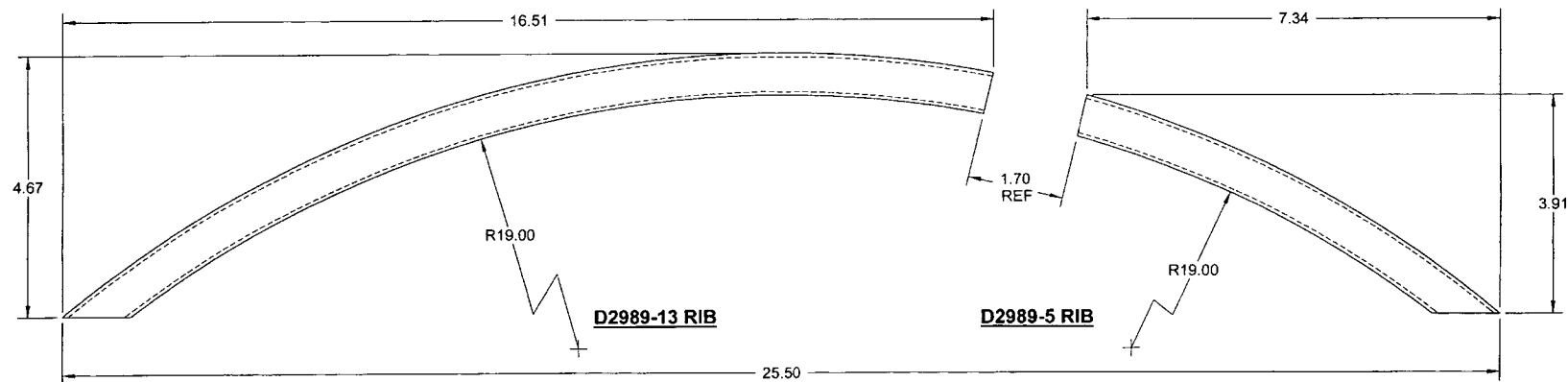


**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18 NW

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

RELEASED
08/11/18